

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008999**Date Inspected:** 14-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG and Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 2:

This QA Inspector observed the following work in progress: SMAW tack welding of Floor beam stiffener welds FB3093-001-048 and 049. ZPMC welder was identified as 207464. ZPMC QC is identified as Li Yang. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2112.

Bay 3-

This QA Inspector observed the following work in progress: SMAW tack welding longitudinal diaphragm weld LD001-041-011. ZPMC welder was identified as 057795. ZPMC QC is identified as Li Yang. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2112.

Bay 5-

This QA Inspector observed the following work in progress: FCAW welding of traveller rail bracket welds, TR1B-PP85-003, TR6C-PP88-005 and TR1E-PP86-009. ZPMC welders were identified as 215185, 215009 and 212250. ZPMC QC is identified as Li Yang. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2232-TC-U4c-F.

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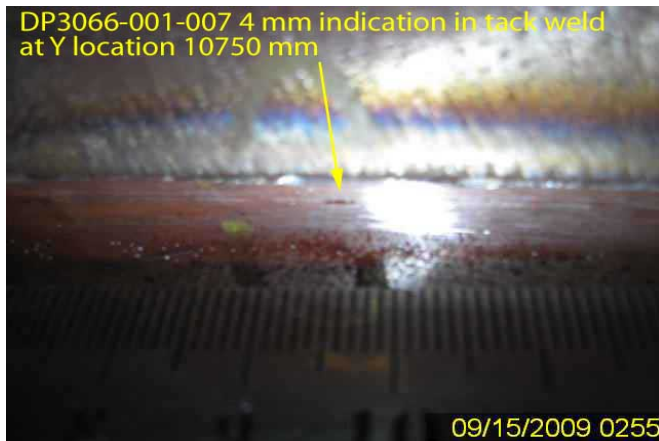
Bay 9-

Caltrans QA performed MT verification of OBG Deck panel DP3066-001 tack welds that were previously tested and accepted by ZPMC MT technicians. One linear indication was marked for additional grinding on weld 7 at Y location 10750 mm. See attached photo of the indication below.

Bay 10-

This QA Inspector observed the following work in progress: SMAW repair welding of West Tower Lift 4 Skin Plate E doubler plate weld, WSD1-FESA4-3 C/F-003. ZPMC welder was identified as 053829. ZPMC QC was identified as Liu Zhong An. The welding appeared to be in conformance with welding procedure specification, WPS-345+485-SMAW-2G(2F)-Repair-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation between QC and QA occurred this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
